

**CLAIM**

1.

1           A restrictor for use in a pulsation-absorbing flexible pipe for a pressure  
2 fluid device, said restrictor comprising a generally cylindrical body having a central flow-  
3 through passage open at its opposite axial ends, said flow-through passage being  
4 constructed in the form of a venturi having a flow-direction-convergent inlet leading into  
5 a constant diameter throat that in turn leads into a flow-direction-divergent outlet, the  
6 configuration of the venturi inlet, throat and outlet being constructed and arranged such  
7 that turbulence in the outlet of the restrictor under the pressure and fluid flow conditions  
8 in which the restrictor is adapted to be used minimizes turbulence in the restrictor outlet  
9 and/or immediately downstream thereof.

2.

1           The restrictor of claim 1 wherein said restrictor body is constructed  
2 entirely of plastic material injection molded in final form to the shape and configuration  
3 specified in claim 1.

3.

1        The restrictor of claim 1 wherein the dimensional parameters as specified  
2        in FIGS. 1 and 2 by the reference characters A through J are generally as follows:

Dimensional Parameter	Value ( in metric units)	Range (in metric units)
A	9.017-8.763 mm	10.033-8.765 mm
B	8°	4°-15°
C	2.64-2.89 mm	2.64-4.57 mm
D	2.667-2.43 mm	.76-12.2 mm
E	7.493 Ref. mm	
F	1.905-1.651 mm	.127-1.651 mm
G	2.667-2.413 mm	.76-2.667 mm
H	.203-.406 mm	.127-.406 mm
I	8.052-9.576 mm	
J	.457-.203 mm	

4.

1        The restrictor of claim 1 wherein the taper angle of said outlet ranges  
2        between approximately 4° up to approximately 15°.

5.

1                   The restrictor of claim 1 wherein the external surface of the restrictor is of  
2 constant diameter and is interrupted in a central region axially thereof by a series of  
3 grooves and intervening lands with sharp intersections, said grooves being of relatively  
4 shallow radial depth to thereby adapt the restrictor for being surrounded by a flexible  
5 hose clamped thereto and sealed by engagement with the grooves and lands of the inner  
6 wall of the hose.

6.

1                   The restrictor of claim 1 in combination with a hose assembly with said  
2 restrictor installed therein and operable in reducing turbulence in fluid when operated in a  
3 hydraulic system, said hose assembly comprising a compliant hose section having a wall  
4 defining a passage extending from a first end to a second end and having a predetermined  
5 inner diameter, said wall being formed of a compliant material permitting volumetric  
6 expansion of said passage in response to an increase in pressure in the fluid,  
7                   said flow restrictor being operably disposed in said hose section for  
8 communicating fluid flowing therein from said first end to said second end of said hose  
9 section via said flow-through passage, said venturi throat having a diameter smaller than  
10 said inner diameter of said hose section to thereby restrict alternating components of said  
11 fluid flow between said ends of said hose section, said venturi restrictor inlet, throat and  
12 outlet being configured to operate as a non-turbulent flow venturi under the conditions  
13 existent in the operation of the hydraulic system.

7.

1                   The combination of claim 6 wherein said restrictor is held fixed in said  
2                   hose section by a clamp member encircling the outside of said hose section in registry  
3                   radially with said restrictor and exerting squeeze forces on said hose.

8.

1                   The combination of claim 7 wherein the external surface of said restrictor  
2                   has a series of shallow grooves and intervening lands with sharp corners at their  
3                   intersection with adjacent flanking grooves.

9.

1                   The combination of claim 8 wherein said restrictor is made of plastic  
2                   material and said clamp is of the hose clamp-type in which said squeeze force is  
3                   developed by circumferentially tensioning said clamp in final assembly with said hose  
4                   section and restrictor.

10.

1                   The combination of claim 8 wherein said restrictor is made of relatively  
2                   high strength material, such as metal or high melting point filled plastic material, and said  
3                   clamp comprises a metal band cold work squeeze-crimped with relatively high forces  
4                   around said hose into a permanently deformed hose constricting shape.

11.

1           The combination of claim 6 wherein said restrictor is coupled at its outlet  
2    in fluid communication with the inlet of a tuning cable conduit extending co-axially with  
3    said hose section downstream of said restrictor outlet in inwardly spaced relation to a  
4    surrounding interior wall of said hose section.

12.

1           The combination of claim 11 wherein said restrictor and said tuning cable  
2    conduit are each made of plastic material and are coupled by being telescopically joined  
3    and plastically welded together.

13.

1           The combination of claim 11 wherein said hydraulic system comprises a  
2    hydraulic power steering system having a hydraulic pump with its output communicating  
3    with a power steering gear via said first-mentioned hose section, said restrictor and tuning  
4    cable thus being combined with said system and operable in the high pressure side  
5    thereof.

14.

1           The combination of claim 13 wherein said system has a return line  
2    operably communicating the outlet of said gear with said pump via a second hose section  
3    and containing another venturi restrictor therein similar to said first-mentioned restrictor  
4    and operable to assist in pressure balancing said power steering system and without  
5    creating audible hiss-like noise therein.

15.

1           A method of eliminating turbulence-induced noise in a pulsation-  
2    absorbing flexible pipe for a pressure fluid device adapted to be connected between a  
3    pressure fluid-feeding device and a working device operated by the pressure fluid  
4    discharged from the pressure fluid-feeding device wherein the flexible pipe has a  
5    restrictor positioned inside the bore of the flexible pipe between the ends of said flexible  
6    pipe and having a flow-through bore,

7           said method comprising the step of:

8           (a)    providing said restrictor as a venturi restrictor wherein the flow-  
9    through bore in said restrictor has a venturi tube cross section with a tapered flow-  
10    direction-convergent inlet bore leading to a constant diameter throat which in turn leads  
11    to a tapered flow-direction-divergent outlet, and

12           (b)    designing said venturi inlet, throat and outlet so as to conduct fluid  
13    therethrough in the operating system of said pressure fluid device by matching the  
14    characteristics of the fluid, the operational pressures, fluid density and other system  
15    parameters such that the venturi operates below the lower critical value of the Reynolds

16 number of the fluid flow through the restrictor to thereby minimize or eliminate noise by  
17 minimizing or eliminating turbulence in the fluid in the restrictor outlet and/or exiting  
18 immediately downstream from the venturi restrictor.

16.

1 The method of claim 15 wherein said restrictor body is constructed  
2 entirely of plastic material injection molded in final form to the shape and configuration  
3 specified in claim 15.

17.

1 The method of claim 15 wherein the taper angle of said restrictor outlet  
2 ranges between approximately 4° up to approximately 15°, and hence the included  
3 divergence angle of the outlet ranges between approximately 8° up to approximately 30°.

18.

1 The method of claim 15 including the further step of installing said  
2 restrictor in said pipe, and wherein said pipe comprises a hose made of elastomeric  
3 material, installing said hose in a hydraulic system containing said device, and wherein  
4 the external surface of the restrictor is of constant diameter and is interrupted in a central  
5 region axially thereof by a series of grooves and intervening lands with sharp  
6 intersections, said grooves being of relatively shallow radial depth, the restrictor being  
7 surrounded by the flexible hose, and clamping the restrictor fixed in the hose so as to be  
8 sealed by engagement of the grooves and lands of the inner wall of the hose.

19.

1           The method of claim 18 wherein said restrictor is made of plastic material  
2 and said clamp is of the hose clamp-type in which hose squeeze force is developed on the  
3 restrictor by circumferentially tensioning said clamp in final assembly with said hose  
4 section and restrictor.

20.

1           The method of claim 15 wherein said flexible pipe comprises a hose  
2 section and said restrictor is coupled at its outlet in fluid communication with the inlet of  
3 a tuning cable conduit extending co-axially with said hose section downstream of said  
4 restrictor outlet in inwardly spaced relation to a surrounding interior wall of said hose  
5 section, and wherein said restrictor and said tuning cable conduit are each made of plastic  
6 material and are coupled by being telescopically joined and plastically welded together.